

APPLICATION FOR LETTERS PATENT OF THE UNITED STATES

ROBERT FULLER  
8752 PINE BARRENS DRIVE  
ORLANDO, FL 32817

A POWER GENERATION SYSTEM INCLUDING AN APPARATUS  
FOR ATTACHING A GENERATOR STATOR CORE TO A  
FRAME SUPPORT AND ASSOCIATED METHODS

TO WHOM IT MAY CONCERN, THE FOLLOWING IS A SPECIFICATION  
OF THE AFORESAID INVENTION

**A POWER GENERATION SYSTEM INCLUDING AN APPARATUS  
FOR ATTACHING A GENERATOR STATOR CORE TO  
FRAME SUPPORT AND ASSOCIATED METHODS**

**Related Applications**

*Ins. >*  
*a'*  
The application is related to U.S. Patent Application  
Attorney Docket No. *11m*  
Serial No. 00P9078US, filed on 12/18/00 by the same inventor  
which is incorporated herein by reference in its entirety.

5

**Field of The Invention**

This invention is related to the power generation industry and, more particularly, to the field of mounting frames supporting stator cores.

10

**Background of the Invention**

In the power generation industry, generator stator cores are supported on mounting frames. As is known in the art, generator stator cores generally include keybars positioned along an outer peripheral surface of the generator stator core. During operation of a power generation system, the generator stator core experiences an "oval mode" condition during which the generator stator core cyclicly deforms. The generator stator core temporarily deforms into an oval shape during operation. The deformations take place along both the horizontal and vertical axis. The "oval mode" condition experienced by the generator stator core accounts for some of the

tangential and radial forces on a power generation system. Manufacturers of power generation systems are often faced with the problem of designing an efficient stator core frame support that can compensate for the "oval mode" condition experience by generator stator cores. Current frame supports are very large and inefficient.

Power generation systems also experience transient faults during operation. When the power generation system experiences a transient fault, the generator stator core is suddenly displaced or rotated and it is difficult for a frame or frame support to sustain the forces associated with the transient fault. Manufacturers and users of high voltage generator stator cores often have great difficulty providing an efficient support for the generator stator core. In order to provide a frame support that is sufficient enough to sustain the forces associated with transient faults experienced during operation of the generator stator core, the frame support is normally very large and extremely inefficient.

Some generator stator core support frames incorporate an outer frame surrounding the core that is then attached to a bedplate or lower frame such as seen in U.S. Patent No. 6,091,177 by Carbonell et al. titled "*Spring Mounting For An Electric Generator*." The mounting frame surrounds the core and connects to all of the keybars positioned on the outer peripheral portions of the core. The surrounding frame is then attached to a lower frame using side and lower connecting members. The combination of these connecting members provides a support frame that is inefficient and cumbersome. Furthermore, the combination of the surrounding frame and the support frame provides a support apparatus with an increased load path, i.e., the load from transient faults and vibratory forces must travel an increased distance.

A similar arrangement for such an apparatus can be found in U.S. Patent No. 4,891,540 by Cooper et al. titled "Generator Core Support System." This support system connects to the generator stator core around the outer periphery of the generator stator core where the keybars are positioned. Similarly, the support system provides a complex and inefficient connection between the generator stator core and the support frame. This connection does not relieve lateral and tangential forces associated with transient faults. Accordingly, excess force from transient faults can cause damage to the generator stator core and frame if the core is not properly fastened to a frame support that can withstand these forces.

As understood by those skilled in the art, it is common to support a power generator stator core on a support frame that includes a connecting member between the generator stator core and the frame support in the six o'clock or twelve o'clock positions, i.e., a connecting member between the lower outer portion of the generator stator core and the stator core frame support. It is also common to support a power generator stator core on a support frame that includes a connecting member between the generator stator core and the frame support in the twelve o'clock position, i.e., a connecting member between an upper outer portion of the generator stator core and the stator core frame support. These configurations of frame supports provide inefficient connections that do not allow for the elimination of lateral forces associated with transient faults that occur during operation.

Additionally, it is costly and time consuming to provide support systems for power generators due to the cumbersome size and configuration of the current support frames necessary for accommodating transient faults and the "oval mode" condition experienced by power generation systems during operation. Some current support systems

are so cumbersome that it is not possible to assemble the core and the core support system separate from one another. Presently, the core and the core support system must be constructed simultaneously. The simultaneous construction of the core and the support frame is extremely costly and time consuming.

#### Summary of the Invention

In view of the foregoing, the present invention advantageously provides a high voltage power generation system including an apparatus for attaching a generator stator core to a frame support and methods of stabilizing a power generation system and reducing vibration and eliminating lateral movement of a generator stator core during operation that are efficient and cost effective. The present invention also advantageously provides an apparatus and methods for protecting a power generation system from the forces associated with transient faults and compensating for deformations that result in radial and tangential forces that are encountered when the generator stator core experiences an "oval mode" condition.

More particularly, the present invention provides a power generation system that includes a stator core frame support member having a lower inner surface portion and a lower outer surface portion. The lower inner surface portion preferably has a substantially semi-annular shape, and the lower outer surface portion is positioned to contact a support surface. The system also includes a generator stator core having a substantially annular shape. The generator stator core includes a plurality of keybars positioned spaced-apart and extending along outer peripheral portions of the generator stator core. The generator stator core is positioned to overlies the lower inner surface portion of the stator core frame support

member and has a lower end portion positioned spaced-apart from and not in contact with bottom portions of the lower inner surface of the stator core frame support member. The upper end portion of the generator stator core is also positioned spaced-apart from and not in contact with the stator core frame support. The system further includes a core supporter connected to the stator core frame support member. The core supporter is positioned to contact a plurality of keybars that are positioned along outer side peripheries of the generator stator core. The core supporter preferably has first and second core connecting means for attaching the stator core frame support member to the generator stator core. The core connecting means relieves vibration and prevents lateral movement of the generator stator core and also stabilizes the power generation system during operation to thereby provide a stator core frame support member that is efficient and cost effective. The first core connecting means is connected to a first medial side outer peripheral portion of the generator stator core and the second core connecting means is connected to a second medial side outer peripheral portion of the generator stator core. The second medial side outer peripheral portion of the generator stator core is positioned opposite the first medial side outer peripheral portion of the generator stator core. The first and second core connecting means are positioned symmetrically along the longitudinal axis of the generator stator core. The combination of the first and second core connecting means connect portions of the stator core frame support member to portions of the generator stator core.

*Ins. 22*

~~This configuration of a the generator stator core and the stator core frame support provides a stable power generation system. This configuration also advantageously relieves vibration and prevents lateral movement of the~~

Year	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	

The present invention still further provides a generator stator core support apparatus for stabilizing a power generation system and for relieving vibration and



*Ins.  
a2  
cont.*

*FIG. 2*

~~eliminating lateral movement of the generator stator core~~  
during operation. The generator stator core support  
apparatus preferably includes first core connecting means  
for connecting the generator stator core to a stator core  
5 frame support when the generator stator core is positioned  
to overlies lower inner surface portions of the stator core  
frame support. The first core connecting means is  
positioned to contact a first outer peripheral medial side  
portion of the generator stator core and to contact a  
10 first upper medial side portion of the stator core frame  
support. The generator stator core support apparatus also  
includes second core connecting means for connecting the  
generator stator core to the stator core frame support.  
The second core connecting means is positioned to contact  
15 a second outer peripheral medial side portion of the  
generator stator core. The second outer peripheral medial  
side portion is positioned opposite the first outer  
peripheral medial side portion of the generator stator  
core. The second core connecting means is further  
20 positioned to contact a second upper medial side portion  
of the stator core frame support. The second medial side  
portion of the stator core frame support is positioned  
opposite the first medial side portion of the stator core  
frame support. The combination of the first and second  
25 core connecting means connects portions of the generator  
stator core to portions of the stator core frame support  
to thereby stabilize the power generation system and  
relieve vibration and prevent lateral movement of the  
generator stator core during operation. The combination  
30 of the first and second core connecting means is further  
positioned to support the generator stator core when  
connected thereto without a support contact between a  
lower end portion of the generator stator core and the  
lower inner surface portions of the stator core frame  
35 ~~support or a support contact between an upper end portion~~



*Ins.  
a2  
cncl'd.*

of the generator stator core and the inner surface  
portions of the stator core frame support. There is no  
longer a stiff support between the generator stator core  
and the stator core frame support when the connecting  
5 support is eliminated between the lower end portion or the  
upper end portion of the generator stator core and the  
stator core frame support. By providing an interstitial  
space between the upper and lower end portions of the  
generator stator core and the inner surface portions of  
10 the stator core frame support, lateral forces associated  
with transient faults that occur during operation of the  
generator stator core are eliminated. This interstitial  
space also relieves vibration of the generator stator core  
during operation and compensates for temporary  
15 deformations that produce tangential and radial forces  
encountered by the generator stator core while  
experiencing an "oval mode" condition during operation.  
By relieving vibration, eliminating lateral movement,  
stabilizing the power generation system and compensating  
20 for the "oval mode" condition, the present invention  
advantageously decreases the load from the generator  
stator core to the stator core frame support. The  
decreased load allows for a smaller and more efficient  
stator core frame support. A smaller frame advantageously  
25 provides a shorter load path along which the load from the  
generator stator core to the stator core frame support  
must travel. This configuration further advantageously  
reduces costs and time associated with providing a support  
frame for a high voltage generator stator core thereby  
30 ~~providing an efficient stator core frame support.~~

The present invention also provides a method of  
stabilizing a power generation system, relieving  
vibration, and eliminating lateral movement of the  
generator stator core during operation. The method  
35 includes the step of attaching a first core supporter

which has a biasing support member that includes an elongate spring bar to a first upper medial side portion of a stator core frame support. The method also includes attaching a second core supporter which also has a biasing support member with an elongate spring bar to a second upper medial side portion of the stator core frame support. The second upper medial side portion is positioned opposite the first upper medial side portion so that the combination of the first and second core supporters is positioned symmetrically along portions of the frame support. The method further advantageously includes positioning the generator stator core having a substantially annular shape to overlies lower inner surface portions of the stator core frame support having a semi-annular shape, connecting the generator stator core to the first core supporter along a first medial side portion of the generator stator core, and connecting the second core supporter to a second medial side portion of the generator stator core. The second medial side portion is preferably positioned opposite the first medial side portion of the generator stator core, and the combination of the connections between the first and second core supporters and the first and second medial side portions of the generator stator core form a connection between the generator stator core and the stator core frame support. The connection between the generator stator core and the stator core frame support advantageously reduces vibration and eliminates lateral forces experienced by the generator stator core, and provides stabilization to the power generation system during operation without a support contact between a lower end portion of the generator stator core and the lower inner surface portions of the stator core frame support or a support contact between an upper end portion of the generator stator core and the stator core frame support.

The method of stabilizing the power generation system provided by the present invention is advantageously reduced in cost. The method further advantageously reduces the time associated with constructing a frame support to stabilize the power generation system. The method also advantageously eliminates lateral force components and reduces vibration forces associated with transient faults during operation of the high voltage generator stator core. The method still further advantageously provides a stator core frame support that is efficient, cost effective, and can compensate for the vertical and horizontal force components associated with the "oval mode" condition experienced by the generator stator core during operation. The method also advantageously decreases the path along which a load must travel between the generator stator core and the stator core frame support.

#### Brief Description of the Drawings

Some of the features, advantages, and benefits of the present invention having been stated, others will become apparent as the description proceeds when taken in conjunction with the accompanying drawings in which:

FIG. 1 is a fragmentary perspective view of a first embodiment of a generator stator core of a power generation system positioned to overlie and mounted to a stator core frame support according to the present invention;

FIG. 2 is a sectional view of a generator stator core of a power generation system mounted to a stator core frame support and taken through line 2-2 of FIG. 1 according to the present invention;

FIG. 3 is a front perspective view of a core connector that includes a spring bar, spring mounting

frames, and bracket spring assemblies according to the present invention;

FIG. 4 is a rear perspective view of a core connector that includes a spring bar, spring mounting  
5 frames, and bracket spring assemblies according to the present invention;

FIG. 5 is a fragmentary perspective view of a connecting assembly between the generator stator core and the stator core frame support member of a power  
10 generation system according to the present invention;

FIG. 6 is a perspective view of a second embodiment of a generator stator core positioned to overlie and mounted to a stator core frame support of a power generation system according to the present invention;

FIG. 7 is a fragmentary perspective view of second  
15 embodiment of a connecting assembly between the generator stator core and the stator core frame support member of a power generation system according to the present invention;

FIG. 8 is a front perspective view of a second  
20 embodiment of a core connector that includes a spring bar passing through spring mounting frames with bracket spring assemblies according to the present invention;

FIG. 9 is a fragmentary perspective view of a third  
25 embodiment of a connecting assembly between a generator stator core and a stator core frame support having a plurality of spring bars according to the present invention; and

FIG. 10 is a front perspective view of third  
30 embodiment of a core connector including a plurality of spring bars according to the present invention.

#### **Detailed Description of Preferred Embodiments**

The present invention will now be described more  
35 fully hereinafter with reference to the accompanying

drawings, in which preferred embodiments of the invention are shown. This invention may, however, be embodied in many different forms and should not be construed as limited to the illustrated embodiments set forth herein.

5 Rather, these illustrated embodiments are provided so that this disclosure will be thorough and complete, and will fully convey the scope of the invention to those skilled in the art. Like numbers refer to like elements throughout, and prime, double prime, and triple prime

10 notations, if used, indicate similar elements in alternative embodiments.

During operation of power generation systems, high voltage generator stator cores experience vibration forces, transient faults, and an "oval mode" condition

15 that includes both tangential and radial forces applied to the power generation system. Transient faults cause the high voltage generator stator core to displace and further put high strains on stator core frame support members during operation. The lateral displacement of the

20 generator stator core, for example, can be of the same order of magnitude as torsional displacements due to torsional forces experienced by the generator stator core during operation. The displacements, high vibratory forces, and tangential and radial forces associated with

25 the "oval mode" condition experienced by generator stator cores during operation cause high levels of strain on stator core frame support members positioned to support the generator stator core. By low tuning the natural frequency of the generator stator core, the power

30 generation system is advantageously reduced in size, complexity and cost.

FIG. 1 illustrates a power generation system **10** that reduces vibratory forces and eliminates lateral force components associated with transient faults and reduces

35 tangential and radial forces associated with the "oval

mode" condition and low tunes the natural frequency of a generator stator **20** during operation. The power generation system **10** includes a stator core frame support member **30** having a lower inner surface portion **32** and a lower outer surface portion **34**. The lower outer surface portion **34** is positioned to rest on a support surface, such as a concrete floor, for example. The lower inner surface portion **32** of the stator core frame support **30** preferably has a substantially semi-annular shape, but other shapes, e.g., rectangular or oval, could also be used as well according to the present invention.

The generator stator core **20** can have a substantially annular shape, but other shapes could also be used as well according to the present invention. The generator stator core **20** preferably includes a plurality of keybars **22**. The keybars **22** can advantageously be made of a steel material. The plurality of keybars **22** are preferably positioned spaced-apart and extend along outer peripheral portions of the generator stator core **20**. The generator stator core **20** is positioned to overlie the stator core frame support member **30** and can advantageously include substantially less than the maximum number of keybars that can be positioned spaced-apart along outer peripheral portions of the generator stator core **20**.

In a second embodiment of the present invention, the generator stator core **20'** can still further advantageously include four keybars **22'**, as illustrated in FIG. 6. Two keybars **22'** can be positioned spaced-apart along a first outer peripheral medial side portion **27'** of the generator stator core **20'**, and another two keybars **22'** can be positioned spaced-apart along a second outer peripheral medial side portion **28'** of the generator stator core **20'**. The first **27'** outer peripheral medial side portion is

positioned opposite the second **28'** outer peripheral medial side portion of the generator stator core **20'** so that the first **27'** and the second **28'** outer peripheral medial side portions are positioned substantially symmetrical along a preferably longitudinal axis of the generator stator core **20'**.

The keybars **22** are elongate and extend substantially the entire length of the generator stator core **20**. The outer periphery of the generator stator core **20** is preferably provided with dovetail slots **26** that extend substantially the entire length of the generator stator core **20**. The dovetail slots **26** are wider at the bottom portion of the slots **26** and more narrow at the upper portion of the slots **26**. Each of the plurality of keybars **22** has portions shaped similar to the dovetail slots **26**. Likewise, the inner portions of the keybars **22** are preferably wider than the outer portion of the keybars **22**. The keybars **22** matingly contact the respective dovetail slots **26** formed in the outer peripheries of the generator stator core **20**.

The power generation system **10** further provides a core supporter connected to the stator core frame support member **30**. The core supporter is further positioned to contact the keybars **22** positioned along outer peripheral portions of the generator stator core **20**. The core supporter preferably includes core connecting means **42** for attaching the stator core frame support member **30** to the generator stator core **20**. The core connecting means preferably includes first **43** and second **44** core connecting means. Each of the first **43** and second **43** core connecting means preferably includes a biasing support member **50**. The biasing support member **50** encompasses structural properties that provide strength for supporting a



connection between the generator stator core **20** and the stator core frame support member **30**. The biasing support member **50** also includes structural properties that provide a supporting connection between the generator stator core **20** and the stator core frame support member **30** that is not rigid. The biasing support member **50** further provides a level of flexure that reduces vibration of the generator stator core **20**, eliminates lateral force components associated with transient faults that occur during operation of the generator stator core **20** and low tunes the natural frequency of the generator stator core **20**.

The structural properties of the biasing support member **50** also advantageously aid in reducing tangential and radial forces associated with the "oval mode" condition experienced by the generator stator core **20** during operation to thereby reduce complexity and cost of the power generation system **10** while simultaneously maintaining stability of the power generation system **10**. The biasing support member **50** can advantageously be provided by an elongate spring bar **52**. The spring bar **52** is positioned between the generator stator core **20** and the stator core frame support member **30** to thereby provide a connector assembly that connects the generator stator core **20** and the stator core frame support member **30**.

The connector assembly is structurally viable and has flexural properties sufficient to absorb vibratory forces, eliminate lateral force components associated with transient faults, low tune the natural frequency of the generator stator core, and stabilize the power generation system **10** during operation of the generator stator core **20**. More particularly, the spring bar **52** is connected to a spring mounting frame **56**. The spring mounting frame **56** is connected to the keybars **22** of the generator stator

core **20** as illustrated in FIG. 5. The spring bar **52** can be composed of steel or another type of material that provides structural support and flexural properties suitable for relieving vibration of a generator stator core **20**, eliminating lateral force components associated with transient faults, reduce tangential and radial force components associated with the "oval mode" condition, and low tune the natural frequency of the generator stator core **20** during operation. The flexural properties of the spring bar **52** also advantageously aid in eliminating rigid connections in power generation systems **10**.

The first **43** and second **44** core connecting means advantageously relieve vibratory, tangential and radial forces associated with operation of the generator stator core **20**, eliminate lateral movement, low tune the natural frequency of the generator stator core **20**, and further advantageously stabilize the power generation system **10**. The first core connecting means **43** is connected to a first medial side outer peripheral portion **27** of the generator stator core **20**. The second core connecting means **44** is connected to a second medial side outer peripheral portion **28** of the generator stator core **20**. The first medial side outer peripheral portion **27** of the generator stator core **20** is positioned opposite the second medial side outer peripheral portion **28** of the generator stator core **20** and is therefore positioned substantially symmetrical along the longitudinal axis of the generator stator core **20**. The combination of the first **43** and second **44** core connecting means connect portions of the generator stator core **20** to portions of the stator core frame support member **30**.

The biasing support member **50** can also advantageously include a plurality of bracket spring assemblies **54**. The

spring bar **52** is advantageously connected to the bracket  
spring assembly **54** as illustrated in FIGS. 3-5. The  
bracket spring assemblies **54** can be positioned spaced-  
apart along the elongate spring bar **52**. Each of the  
5 plurality of bracket spring assemblies **54** also includes a  
spring mounting frame **56** and a plurality of spaced-apart  
key block brackets **60**. The spring bar **52** connects to each  
of the plurality of bracket spring assemblies **54** along  
center portions of the bracket spring assemblies **54**. More  
10 particularly, the spring bar **52** is positioned to connect  
to outer center portions of each of the plurality of  
bracket spring assemblies **54**. The spring bar **52** can  
connect to the bracket spring assemblies **54** by welding  
exterior portions of the bracket spring assemblies **54** to  
15 portions of the spring bar **52**. The spring bar **52** can also  
connect to the bracket spring assemblies **54** using any  
other type of connection that can be made between metals  
that has the structural and flexural properties to reduce  
vibration and eliminate lateral forces of the generator  
20 stator core **20** and to further stabilize the power  
generation system **10** during operation.

In a third embodiment of the present invention, the  
spring bar **52"** can connect to the bracket spring  
assemblies **54"** through a center portion of the bracket  
25 spring assemblies **54"** as illustrated in FIGS. 7-8. In  
this embodiment, the bracket spring assemblies **54"** include  
an opening **59"** formed in a medial portion. The dimensions  
of the opening **59"** are substantially similar to the  
dimensions of the spring bar **52"**. A connection is made  
30 between the spring bar **52"** and the bracket spring  
assemblies **54"** by slidably engaging the elongate spring  
bar **52"** with the opening **59"** formed in each of the  
plurality of bracket spring assemblies **54"**. The

connection between the spring bar **52"** and the bracket spring assemblies **54"** can be strengthened by welding portions of the spring bar **52"** to portions of the bracket spring assemblies **54"** along the openings **59"** formed in the medial portions of the bracket spring assemblies **54"**.

In a fourth embodiment of the present invention, a plurality of spring bars **52"** can be provided, as illustrated in FIGS. 9-10. The stiffness of the plurality of spring bars **52"** combined, i.e., as illustrated in FIG. 9, is substantially similar to the stiffness of a single spring bar **52**, i.e., as illustrated in a first embodiment of the present invention in FIG. 5. The plurality of spring bars **52"** also includes a plurality of bracket spring assemblies **54"** positioned spaced-apart along the plurality of elongate spring bars **52"**. The plurality of spring bars **52"** extend substantially parallel to each other substantially the entire length of the generator stator core **20"**. The plurality of spring bars **52"** are advantageously connected to the plurality of bracket spring assemblies **54"** along end portions of the bracket spring assemblies **54"** so that the plurality of spring bars **52"** are positioned opposite each other and symmetrical along the bracket spring assemblies **54"**. This configuration of the present invention is advantageous because each of the plurality of spring bars **52"** can advantageously have a lower stiffness than in the first embodiment of the present invention where only a single spring bar **52** per core supporter is included. This configuration also advantageously reduces vibration and eliminates lateral movement of the generator stator core **20"**, low tunes the natural frequency of the generator stator core **20**, and further advantageously stabilizes the power generation system **10"** during operation. This

configuration still further advantageously compensates for tangential and radial forces associated with the "oval mode" condition experienced by the generator stator core 20" during operation.

5       The key block brackets 60 are connected to the spring mounting frame 56 as illustrated in FIGS. 3-4. More particularly, the plurality of key block brackets 60 include first 61 and second 62 key block brackets. The first key block bracket 61 is positioned to connect to a  
10 first end portion of the spring mounting frame 56 and the second key block bracket 62 is positioned to connect to a second end portion of the spring mounting frame 56. The first key block bracket 61 preferably includes a first key block 64 and the second key block bracket 62 includes a  
15 second key block 64. The first and second key blocks 64 are positioned to matingly contact the first and second key block brackets 60.

One of the plurality of key blocks 64 is also positioned to contact one of the plurality of keybars 22  
20 positioned along the outer peripheral portions of the generator stator core 20 and is further positioned to contact the stator core frame support 30. The plurality of key blocks 64 are positioned to contact portions of the generator stator core 20 and portions of the stator core  
25 frame support 30. As illustrated in FIGS. 3-5, each of the plurality of key block brackets 60 and each of the plurality of key blocks 64 includes openings 68 that align with one another. Each of the plurality of keybars 22 can also include a plurality of openings 68. The openings 68  
30 in the key block brackets 60, the key blocks 64, and the keybars 22 can advantageously be threaded. When the openings 68 on the key blocks 64, the key block brackets 60, and the key bars 22 are aligned, a connection can be

made between the generator stator core **20** and the stator core frame support **30** by positioning a connecting member **15** therethrough.

The connecting member **15** can advantageously be provided by a bolt, or another type of connecting assembly that can pass through portions of the key block bracket **60**, the key block **64**, and the key bar **22**. The connecting member **15** can be any strong steel material that can withstand vibratory, radial, and vertical forces associated with the operation of the generator stator core **20** or lateral movement associated with transient faults. The connecting member **15** can also be threaded to thereby make a strong connection to the threaded openings **68** positioned on the key block **64**, the key block brackets **60**, and the key bar **22**.

The core supporter can advantageously be positioned to contact less than all of the keybars **22** positioned along outer peripheral portions of the generator stator core **20**, as illustrated in FIG. 2. This configuration advantageously reduces cost and complexity of the power generation system **10** by low tuning the natural frequency of the generator stator core, relieving vibratory forces, preventing lateral movement and compensating for tangential and radial forces associated with the "oval mode" condition experienced by the generator stator core **20** during operation while simultaneously maintaining stability of the power generation system **10**. Because the core supporter can be positioned to contact less than all of the keybars **22**, the configuration is advantageously less expensive to manufacture and less time consuming to assemble.

As illustrated in FIGS. 3-5, a generator stator core support apparatus for stabilizing a power generation

system 10 is also provided. The generator stator core support apparatus includes first 43 and second 44 core connecting means 42 for connecting the generator stator core 20 to a stator core frame support 30. The first core  
5 connecting means 43 is positioned to contact a first outer peripheral medial side portion 27 of the generator stator core 20 and is also positioned to contact a first upper medial side portion of the stator core frame support 30. The contact made between the first core connecting means  
10 43 and the first upper medial side portion 27 of the stator core frame support 30 forms a connection between the first core connecting means 43 and the stator core frame support 30. This connection can be formed by a weld or any other connection between metal material that forms  
15 a strong bond that will not deteriorate over the life of the generator stator core 20.

The second core connecting means 44 is positioned to contact a second outer peripheral medial side portion 28 of the stator core frame support 30. The second outer  
20 peripheral medial side portion 28 of the stator core frame support 30 is positioned opposite the first outer peripheral medial side portion 27 of the stator core frame support 30. The contact between the second core connecting means 44 and the stator core frame support 30  
25 also forms a connection between the second core connecting means 44 and the stator core frame support 30. This connection can also be a welded connection, or any other connection that forms a strong bond between metal materials.

30 The present invention provides a more efficient and cost effective power generation system 10 by low tuning the natural frequency of the generator stator core 20 while simultaneously maintaining stability of the power



generation system **10**. The stiffness of the stator core frame support **30** and biasing support member **50** is decreased, the generator stator core **20** can advantageously operate at a lower tuned natural frequency. Typical  
5 generator stator cores **20** can operate at frequencies higher than 60 hertz (HZ), while a low tuned generator stator core **20** operates at a natural frequency of less than 60 HZ. By providing a generator stator core **20** that  
10 operates at a lower tuned natural frequency, for example, between 10-25 HZ, a smaller and more efficient stator core frame support **20** can advantageously be provided in a stable power generation system **10**.

As shown in FIGS. 1-10, methods of stabilizing a power generation system **10**, relieving vibration forces,  
15 eliminating lateral movement, and low tuning the natural frequency of a generator stator core **20** are also provided in the present invention. The method includes the step of attaching a first core supporter **43** to a first upper medial side portion of a stator core frame support **30**.  
20 The first core supporter **43** preferably includes a biasing support member **50**. The method still further includes the step of attaching a second core supporter **44** to a second medial side portion of the stator core frame support **30**. The second core supporter **44** also includes a biasing  
25 support member **50**. In turn, the biasing support member **50** preferably includes an elongate spring bar **52**. The second upper medial side portion of the stator core frame support **30** is positioned opposite the first upper medial side portion of the stator core frame support **30**. The first **43**  
30 and second **44** core supporters can advantageously be attached to the stator core frame support **30** by welding portions of the first **43** and second **44** core supporters to portions of the stator core frame support **30**. The

combination of the first **43** and second **44** core supporters are positioned substantially symmetrical along portions of the stator core frame support **30**.

The method of stabilizing the power generation system **10**, and low tuning the natural frequency of the generator stator core **20** by positioning the generator stator core **20** to overlies the stator core frame support **30** advantageously provides a more cost-efficient and less complex power generation system. The lower portion **24** of the generator stator core **20** is positioned to overlies the stator core frame support **30** so that the lower portion **24** of the generator stator core **20** can be positioned within the lower inner surface **32** of the stator core frame support **30** without contact between the lower portion of the generator stator core **20** and the stator core frame support **30**.

The method of stabilizing the power generation system **10**, reducing vibration, eliminating lateral movement and low tuning the natural frequency of the generator stator core **20** during operation still further includes connecting the generator stator core **20** to the first core supporter **43** along a first medial side portion **27** of the generator stator core **20** and further connecting the generator stator core **20** to the second core supporter **44** along a second medial side portion **28** of the generator stator core **20**. These connections are made by using a plurality of connecting members **15**. Each one of the plurality of connecting members **15** are positioned through each of the first **43** and second **44** vibration reducers **42** and into key bars **22** positioned along outer peripheral portions of the generator stator core **20**.

The plurality of connecting members **15** can advantageously be provided by bolts, for example, or another type of connecting member that can contact each of

the first **43** and second **44** core supporters and portions  
the key bars **22** positioned along outer peripheral portions  
of the generator stator core **20**. Each of the plurality of  
connecting members **15** can advantageously be steel, or  
5 another metal material having strength properties capable  
of withstanding the vibratory forces and lateral movement  
associated with transient faults and tangential and radial  
forces associated with the "oval mode" condition  
experienced by the generator stator core **20** during  
10 operation.

The combination of the plurality of connecting  
members **15** and the first **43** and second **44** core supporters  
in contact with the first **27** and second **28** medial side  
portions of the generator stator core **20** form a connection  
15 between the generator stator core **20** and the stator core  
frame support **30** that advantageously further provides  
stabilization to the power generation system **10** during  
operation of the generator stator **20**, reduces vibration,  
eliminates lateral movement and low tunes the natural  
20 frequency of the generator stator core **20**.

The method still further includes attaching a  
plurality of keybars **22** to outer peripheral portions of  
the generator stator core **20** and positioning the keybars  
**22** spaced-apart along the outer peripheral portions of the  
25 generator stator core **20**. Each of the plurality of  
keybars **22** has a portion that includes a dovetail shape  
**26**. Each of the plurality of keybars **22** slidably contacts  
a dovetail slot **26** formed in the outer peripheral portion  
of the generator stator core **20**. The method also includes  
30 contacting the keybars **22** with the first **43** and second **44**  
core supporters **42** to thereby connect the generator stator  
core **20** to the stator core frame support **30**. The step of  
connecting the keybars **22** to the core supporters **42**

advantageously stabilizes the power generation system **10** during operation.

The step of connecting core supporters **42** to the generator stator core **20** can advantageously be accomplished by connecting the core supporters **42** to less than all of the keybars **22**. Furthermore, the step of connecting the core supporters **42** to the generator stator core **20** can also include connecting only the core supporters **42** to keybars **22** positioned along medial side portions of the generator stator core **20** so that there is no connection between the generator stator core **20** and the stator core frame support **30** along bottom surfaces of the generator stator core **20**. This method can still further include connecting the core supporters **42** to the key bars **22** positioned along medial side portions of the generator stator core **20** so that there is no connection between the generator stator core **20** and the stator core frame support **30** along upper surfaces of the generator stator core **20**. This provides an interstitial space between the lower end portion **24** of the generator stator core **20** and the lower inner surface **32** of the stator core frame support **30** and between the upper surface of the generator stator core **20** and the stator core frame support **30** that advantageously eliminates lateral forces and reduces vibration of the generator stator core **20** associated with transient faults. The interstitial space also compensates for tangential and radial forces associated with the "oval mode" condition experienced by the generator stator core **20** during operation. The interstitial space provided by the present invention still further stabilizes the power generation system **10** and low tunes the natural frequency of the generator stator core **20**.

The method of stabilizing the power generation system **10** during operation also includes extending the first core supporter **43** substantially parallel to the second core supporter **44**, substantially the entire length of the generator stator core **20**. The method further includes attaching a plurality of bracket spring assemblies **54** to the elongate spring bar **52**. The elongate spring bar **52** can advantageously be a strong steel material. Each of the plurality of bracket spring assemblies **54** includes a spring mounting frame **56**.

The method still further includes attaching first **61** and second **62** key block brackets to the spring mounting frame **56**. The first key block bracket **61** includes a first key block **64** and the second key block bracket **62** includes a second key block **64**. The method further includes matingly contacting each of the first and second key blocks **64** with each of the first **61** and second **62** key block brackets, and connecting the first key block bracket **61** to a first end portion of the spring mounting frame **56** and the second key block bracket **62** to a second end portion of the spring mounting frame **56**. The first and second end portions of the spring mounting frame **56** are positioned opposite each other. The method still further includes connecting one of the plurality of key blocks **64** to a portion of one of the plurality keybars **22** positioned along outer peripheral portions of the generator stator core **20**. The key block **64** is positioned to connect the stator core frame support **30** to the generator stator core **20**.

This method of stabilizing the power generation system **10** provides an interstitial space between the upper and lower end portions of the generator stator core **20** and the stator core frame support **30** and low tunes the natural

frequency of the generator stator core **20** advantageously relieving vibratory forces associated with operation of the generator stator core **20**. The method further eliminates lateral movement associated with transient faults that occur during operation of the generator stator core **20**. The method of stabilizing the power generation system **10** during operation of the generator stator core **20** advantageously reduces the size of the stator core frame support **30**, thereby reducing costs associated with providing a stator core frame support **30**. The reduced size of the stator core frame support **30** advantageously reduces the path of a load traveling from the generator stator core **20**. Furthermore, the method advantageously allows a user or manufacturer to construct the generator stator core **20** and the stator core frame support **30** separately. When the manufacturer constructs the generator stator core **20** and the stator core frame support **30** separately, instead of simultaneously, the manufacturer is provided with more flexibility in time and cost associated with constructing the generator stator core **20** and the stator core frame support **30**.

In the drawings and specification, there have been disclosed embodiments of the invention, and although specific terms are employed, the terms are used in a descriptive sense only and not for purposes of limitation. The invention has been described in considerable detail with specific reference to these illustrated embodiments. It will be apparent, however, that various modifications and changes can be made within the spirit and scope of the invention as described in the foregoing specification and as defined in the appended claims.